

# Work Order ID 50875

July 23, 2009 9:56:42 AM

Page 1

Item ID: D2229

Accept

Revision ID: B

Item Name: Doubler

Setup Start

Stop

Start Date: 27/07/2009 Start Qty: 60.00

Required Date: 31/07/2009 Req'd Qty: 60.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 09-07-23 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2229

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2229 11 Dwg Rev: B 12 Prog Rev: B 12-  
Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 8/07/09/21

cuts

(60)

6

*mf*

09

08

20

(60)

*mf*

09

08

21

(60)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2229 PAR #: N/A Fault Category: Sm Fab NCR: Yes No DQA: ls Date: 09.08.24  
 Resolution: accepted Disposition: use as is QA: N/C Closed: ls Date: 09.08.27

NCR: 50875		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.08.21	100	Qty (39) DOUBTERS HAVE ENLARGED HOLES → Ø0.325 R.L. wrote Set Problems	<u>CP</u> 09.08.21 per QSI 042	Acceptable. DOES NOT AFFECT STRENGTH OF DOUBTER	<u>ml</u> 09.08.21	<u>S</u> 09/06/21	<u>CP</u> 09.08.21 per QSI 042	<u>S</u> 02/06/21

NOTE: Date & initial all entries

# Work Order ID 50875

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Setup Start

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Start Date: 27/07/2009 Start Qty: 60.00

Required Date: 31/07/2009 Req'd Qty: 60.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Deburr. No sharp edges

0.00

0.00

ml 09 08 21 (Signature)

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

(x60) mo 09/08/21

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

=> 502/02/21

(x60) 460 (Signature)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50875

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Setup Start

Stop

Start Date: 27/07/2009 Start Qty: 60.00

Required Date: 31/07/2009 Req'd Qty: 60.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

9/8/21 60x Sp

72 1650821

MF 09-08-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

July 23, 2009 9:56:42 AM

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Work Order ID: 50875

Parent Item: D2229RevB

Parent Item Name: Doubler

Comments:

Start Date: 27/07/2009

Required Date: 31/07/2009

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	150.7360	3.2905			



2024-T3 .063 sheet



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	150.7360005	
102942	1.5	
105916	3.69	
106223	1.47	
109463	24.2	
110980	15.45	
111787	102.426001	
19059	2	

*mt 09 08 20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	50875
Description: Doubler		Part Number:	D2229
Inspection Dwg: D2229      Rev: B			Page 1 of 1

☒ **First Article**      ☐ **Prototype**[illegible]

Measured by: <i>M.M</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: <i>09/08/21</i>	Date: <i>09/08/21</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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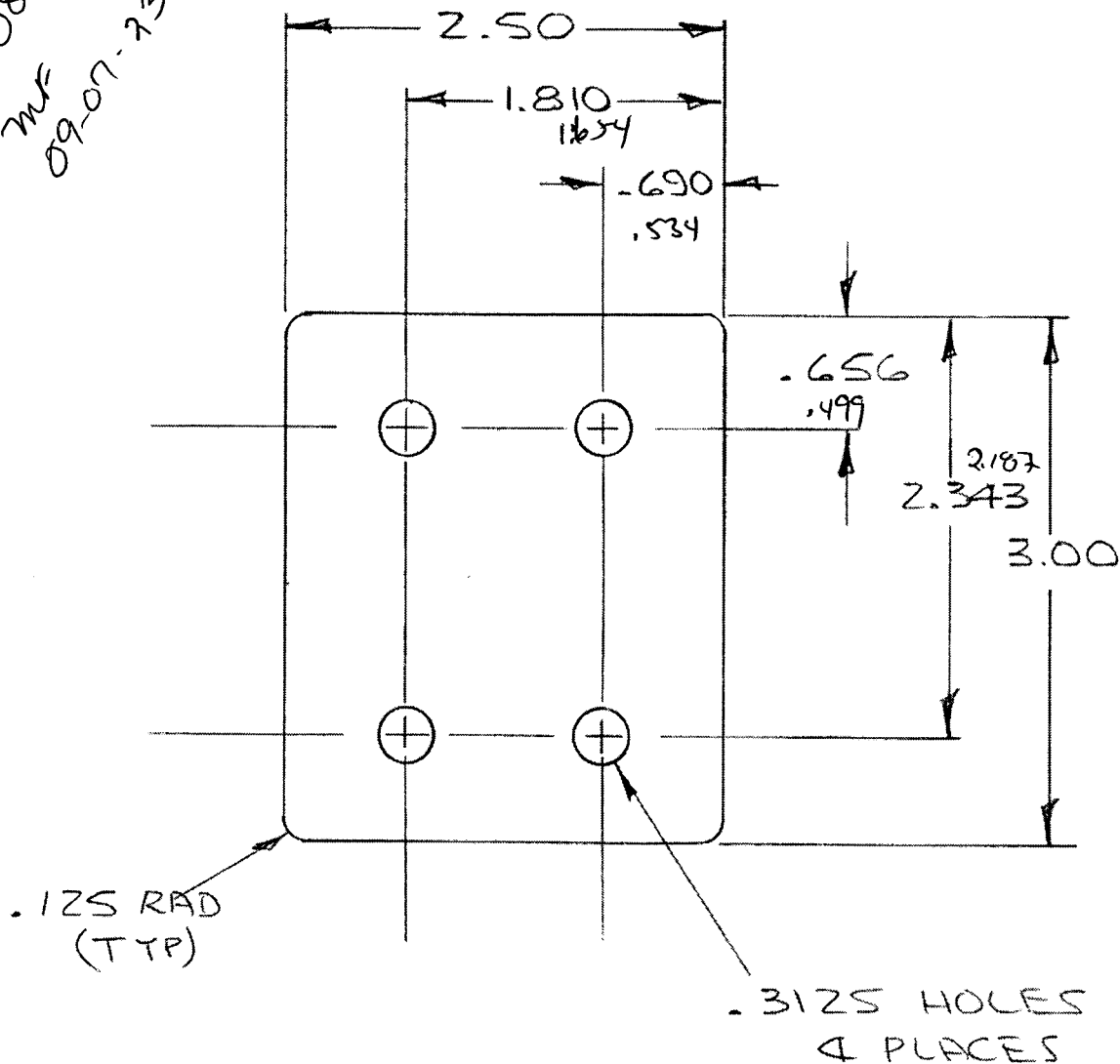
**DART**



DRAWN BRADLEY 94-3.28		<b>DART AERO ACCESSORIES INC</b> VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN BRADLEY 94-3.28		DRAWING NO. D2229	REV. <b>B</b>
		SHEET 1 OF 1	
		TITLE DOUBLER	

A	NEW ISSUE	94/3/8	<i>[initials]</i>
B	ALODINE WAS ANODIZE	97/11/06	<i>[initials]</i>

#50875  
WF  
09-07-23



MATERIAL: 2024-T3 ALUMINUM  
.063 THICK

FINISH: ALODINE PER QSI 005-4.1

1.656

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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